

Work Order ID 63939

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Monday, November 29, 2010 2:46:11 PM

Item ID: D4006-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 11/19/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4006

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev:

Prog Rev:

2-Deburr if necessary

B10-11-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-11-29

Work Order ID 63939

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Item ID: D4006-1

Accept

Revision ID:

Item Name: Angle

Start Date: 11/19/2010 Start Qty: 4.00

Required Date: 11/30/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8 10/11/29

(74)

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

SB 10/11/30

(4)

Brake NC

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

=> JM 10/11/30

4

8

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63939

Friday, November 19, 2010 1:02:40 PM



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Item ID: D4006-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 11/19/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC Inspect part completeness to step on W/O <i>QC3 - inspect chemical coat.</i> Memo <i>10/11/30</i>	0.00 0.00							<i>Pho 7</i>
170 Packaging Packaging	Identify as per dwg & Stock Location: <i>111</i> Memo	0.00 0.00							<i>10/11/30</i> <i>(408)</i>
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>CK 10/12/01</i> <i>(4)</i> <i>Pho 10-11-30</i>

W/O: 63939		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/16/30	160	change ac5 to a ac3 inspection	<i>[Signature]</i>	10.12.01			<i>[Signature]</i> 10/4/30

Part No: D4006-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, November 19, 2010 1:02:40 PM

Work Order ID: 63939



Parent Item: D4006-1



Parent Item Name: Angle


Start Date: 11/19/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.18 new issie Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063  2024-T3 .063 sheet		Purchased	No			100	sf	81.3100	1	4			



FB 10-11-09

Location

Loc Qty

Loc Code

MAT22

81.31

113866

0.81

114351

80.5

113866

4

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63939
Description: ANGLE	Part Number:	D4006-1
Inspection Dwg: D 4006-1, Rev: A		Page 1 of 1

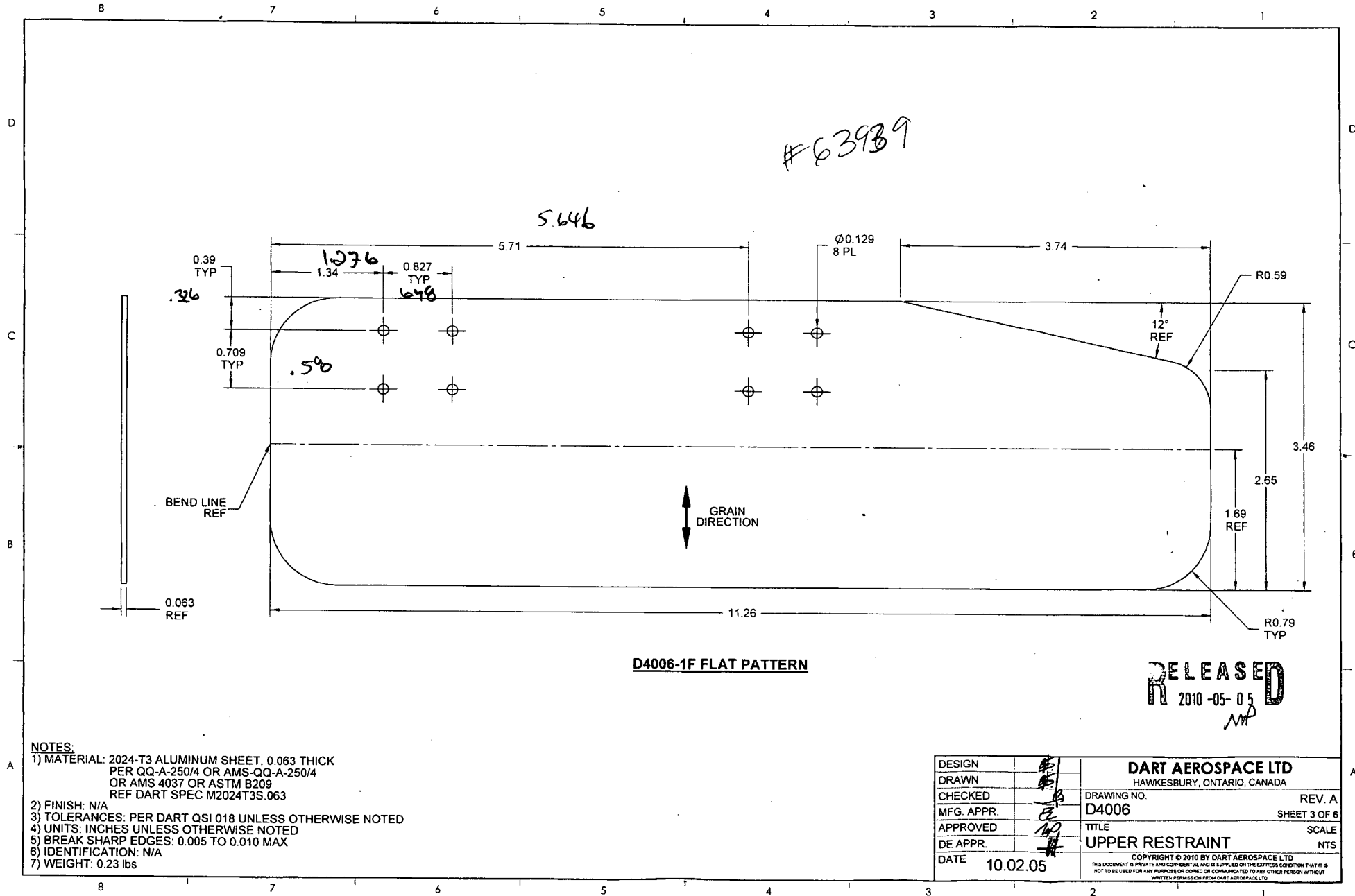
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype
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[illegible]

Measured by:	RB	Audited by:	[Signature]	Prototype Approval:	
Date:	10-11-29	Date:	10/16/25	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

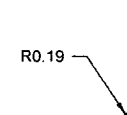
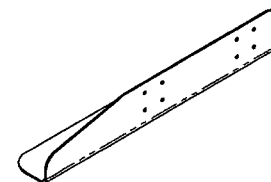
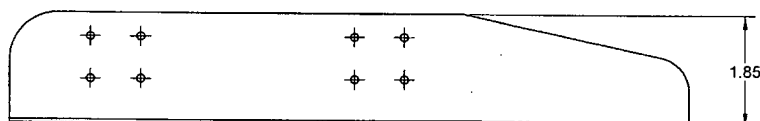
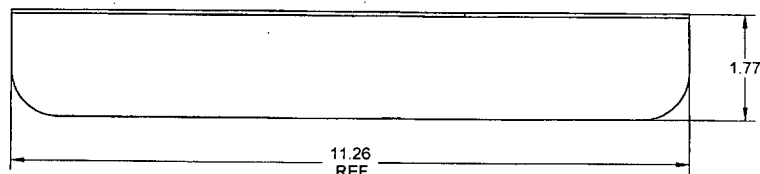
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NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-1	REF JCA-M47-2-01



D4006-1 ANGLE

63939

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4006
MFG. APPR.		REV. A
APPROVED		SHEET 2 OF 6
DE APPR.		TITLE UPPER RESTRAINT
DATE	10.02.05	SCALE NTS

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